

## SECTION 05500 - METAL FABRICATIONS

### PART 1 - GENERAL

#### 1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to this Section.

#### 1.2 SUMMARY

- A. This Section includes the following:
  - 1. Metal ladders.
  - 2. Custom metal fence and gate panels.
  - 3. Custom pattern metal fabrications.
  - 4. Steel framing and supports for ceiling hung toilet compartments.
  - 5. Steel framing and supports for applications where framing and supports are not specified in other Sections.
- B. Related Sections include the following:
  - 1. Division 5 Section "Structural Steel" for structural steel framing system components.
  - 2. Division 5 Section "Pipe and Tube Railings" for metal pipe and tube handrails and railings.

#### 1.3 SUBMITTALS

- A. Shop Drawings: Detail fabrication and erection of each metal fabrication indicated. Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items.
  - 1. Provide templates for anchors and bolts specified for installation under other Sections.

#### 1.4 QUALITY ASSURANCE

- A. Fabricator Qualifications: A firm experienced in producing metal fabrications similar to those indicated for this Project and with a record of successful in-service performance, as well as sufficient production capacity to produce required units.

#### 1.5 PROJECT CONDITIONS

- A. Field Measurements: Where metal fabrications are indicated to fit walls and other construction, verify dimensions by field measurements before fabrication and indicate measurements on Shop Drawings. Coordinate fabrication schedule with construction progress to avoid delaying the Work.

#### 1.6 COORDINATION

- A. Coordinate installation of anchorage for metal fabrications. Furnish setting drawings, templates, and directions for installing anchorage, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in concrete or masonry. Deliver such items to Project site in time for installation.

### PART 2 - PRODUCTS

#### 2.1 METALS, GENERAL

- A. Metal Surfaces, General: For metal fabrications exposed to view in the completed Work, provide materials with smooth, flat surfaces without blemishes. Do not use materials with exposed pitting, seam marks, roller marks, rolled trade names, or roughness.

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## 2.2 FERROUS METALS

- A. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- B. Stainless-Steel Sheet, Strip, Plate, and Flat Bars: ASTM A 666, Type 304.
- C. Steel Tubing: Cold-formed tubing complying with ASTM A 500.
- D. Steel Pipe: ASTM A 53, standard weight (Schedule 40), unless another weight is indicated or required by structural loads.
- E. Galvanized Steel Sheet: ASTM A 653/A 653 M, G909 (Z275) coating, either commercial quality or structural quality, Grade 33 (Grade 230), unless other grade is required for design loads.
- F. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.

## 2.3 ALUMINUM

- A. Aluminum Extrusions: ASTM B 221 (ASTM B 221M), alloy 6063-T6.

## 2.4 PAINT

- A. Shop Primers: Provide primers that comply with Division 9 Section "Painting."
- B. Bituminous Paint: Cold-applied asphalt mastic complying with SSPC-Paint 12, except containing no asbestos fibers, or cold-applied asphalt emulsion complying with ASTM D 1187.

## 2.5 FASTENERS

- A. General: Provide Type 304 or 316 stainless-steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM B 633,

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Class Fe/Zn 5, where built into exterior walls. Select fasteners for type, grade, and class required.

## 2.6 FABRICATION, GENERAL

- A. Shop Assembly: Pre-assemble items in shop to greatest extent possible to minimize field splicing and assembly. Disassemble units only as necessary for shipping and handling limitations. Use connections that maintain structural value of joined pieces. Clearly mark units for reassembly and coordinated installation.
- B. Shear and punch metals cleanly and accurately. Remove burrs.
- C. Ease exposed edges to a radius of approximately **1/32 inch (1 mm)**, unless otherwise indicated. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- D. Weld corners and seams continuously to comply with the following:
  - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
  - 2. Obtain fusion without undercut or overlap.
  - 3. Remove welding flux immediately.
  - 4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
- E. Provide for anchorage of type indicated; coordinate with supporting structure. Fabricate and space anchoring devices to secure metal fabrications rigidly in place and to support indicated loads.
- F. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.
- G. Fabricate joints that will be exposed to weather in a manner to exclude water, or provide weep holes where water may accumulate.

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- H. Allow for thermal movement resulting from the following maximum change (range) in ambient and surface temperatures by preventing buckling, opening up of joints, overstressing of components, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.
  - I. Form exposed work true to line and level with accurate angles and surfaces and straight sharp edges.
  - J. Remove sharp or rough areas on exposed surfaces.
  - K. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible. Use exposed fasteners of type indicated or, if not indicated, Phillips flat-head (countersunk) screws or bolts. Locate joints where least conspicuous.

## 2.7 METAL LADDERS

- A. General: Fabricate ladders for locations shown, with dimensions, spacings, details, and anchorages as indicated.
  - 1. Comply with ANSI A14.3, unless otherwise indicated.
- B. Siderails: Continuous, 1/2-by-2-1/2-inch (12-by-64-mm) flat bars, with eased edges.
- C. Bar Rungs: Safety tread rungs, spaced 12 inches (300 mm) o.c.
- D. Fit rungs in centerline of side rails; plug-weld and grind smooth on outer rail faces.
- E. Provide nonslip surfaces on top of each rung.
- F. Support each ladder at top and bottom with welded or bolted metal brackets. Size brackets to support design loads specified in ANSI A14.3.

## 2.8 MISCELLANEOUS FRAMING AND SUPPORTS

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### METAL FABRICATIONS



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- A. General: Provide steel framing and supports that are not a part of structural-steel framework as necessary to complete the Work.
  - B. Fabricate units from structural-steel shapes, plates, and bars of welded construction, unless otherwise indicated. Fabricate to sizes, shapes, and profiles indicated and as necessary to receive adjacent construction retained by framing and supports. Cut, drill, and tap units to receive hardware, hangers, and similar items.

## 2.9 FINISHES, GENERAL

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.
- B. Finish metal fabrications after assembly.

## 2.10 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. As-Fabricated Finish: AA-M10 (Mechanical Finish: as fabricated, unspecified).

# PART 3 - EXECUTION

## 3.1 INSTALLATION, GENERAL

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing metal fabrications to in-place construction. Include threaded fasteners for concrete and masonry inserts, toggle bolts, through-bolts, lag bolts, wood screws, and other connectors.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal fabrications. Set metal fabrications accurately in location,



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alignment, and elevation; with edges and surfaces level, plumb, true, and free of rack; and measured from established lines and levels.

- C. Provide temporary bracing or anchors for items that are to be built into construction.
- D. Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.
- E. Field Welding: Comply with the following requirements:
  - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
  - 2. Obtain fusion without undercut or overlap.
  - 3. Remove welding flux immediately.
  - 4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
- F. Corrosion Protection: Coat surfaces of aluminum that will come into contact with grout, concrete, masonry, wood, or dissimilar metals with a heavy coat of bituminous paint.

### 3.2 INSTALLING MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Install framing and supports to comply with requirements of items being supported, including manufacturers' written instructions and requirements indicated on Shop Drawings, if any.
- B. Anchor supports for operable partitions securely to and rigidly brace from building structure.



### 3.3 ADJUSTING AND CLEANING

- A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with the same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.
  - 1. Apply by brush or spray to provide a minimum 2.0-mil (0.05-mm) dry film thickness.

END OF SECTION 05500

